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(71) Applicant: MAZDA MOTOR CORP

(72) Inventor: FUJII HIROSHI  
TANAKA FUYUHIKO

### (54) METHOD FOR CASTING CAST-IN OF DIFFERENT KIND OF MATERIAL

(57) Abstract:

**PURPOSE:** To make molten metal running good and to improve joinness by executing cast-in casting with a mold arranging excess metal part at side part of joining faces between cast metal member and the different kind of metal member and removing the excess metal part after casting.

**CONSTITUTION:** A cylinder block 20 is made of Al alloy as the cast metal member 22 and inserted with cast iron-made upper bearing insert 24, lower bearing insert 26 and cylinder liner 28 as the cast-in. At the time of inserting the cylinder liner 28 as the cast-in, at the side part of the joining faces 40 between the cast metal base material 22 in the inner face of the mold and the cylinder liner 28, space forming the excess metal part 42 having annular grooving shape along the outer periphery of the cylinder liner 28 is formed, and detachment at the joining faces 40 is prevented by this excess metal space. The size of the excess metal part 42 is made to  $l_6$  and  $l_7$ , and they are removed with cutting, etc., after casting. By this method, the joining face with the different kind of metal is not brought into contact

with the tip part of the cooled molten metal but is made so as to bring into contact with the non-cooled molten metal, and the molten metal running is made to good and the joinness is improved and the development of the detachment can be reduced.

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